

Date: Monday, 03/11/2008 1:31:25 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 43171	
Estimate Number : 12712	
P.O. Number :	Part Number : D35371
This Issue : 03/11/2008 S.O. No. :	Drawing Number : D3537 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 42820	Material :
Written By :	Due Date : 19/11/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JUD 08-11-03</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.1113 sf(s)/Unit Total: 4.4520 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 109057 HB 8-11-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: E

Prog Rev: E

HB 8-11-4

(48)

2-Deburr if necessary HB 8-11-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-11-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/11/05 (48) center

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

508/11/05 (48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: WEARPAD

Job Number: 43171

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat M109303 X 21 M109893 X 27  
1-Weld as per Dwg D3537 using Jig DT 8210  
2-Remove any weld that penetrated through Wearpad if necessary

EL 8-11-19 X48

7.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/11/19 (48X)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/19 counter (48X)

9.0 POWDER COATING

POWDER COATING



M 106442



(48X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00  
320°F  
2:30

M-J 08/11/20

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-20 (48X)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 17 M-J 08/11/20

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/24 JG

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

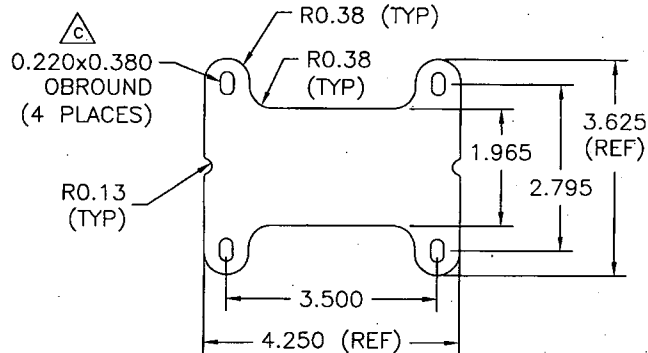
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

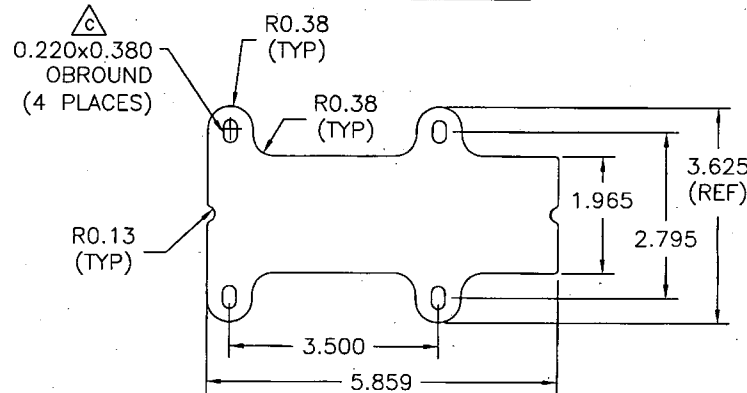
**NOTE:** Date & initial all entries



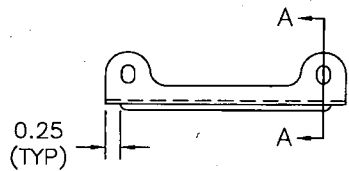
### D3537-1F FLAT PATTERN



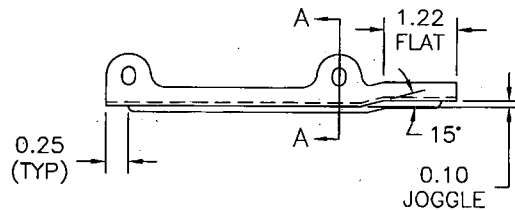
### D3537-3F FLAT PATTERN



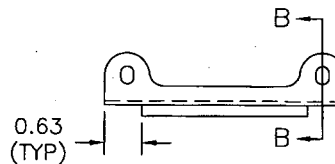
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



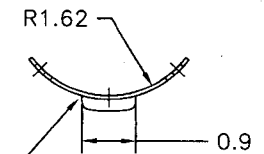
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

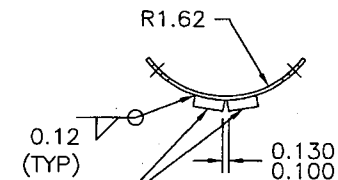
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

### SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

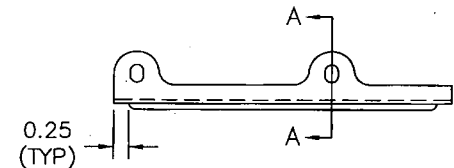
### SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

**RELEASED**  
07.05.03 AH  
PCR ECU 962

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	
DRAWING NO.	D3537	REV. C
TITLE	WEARPAD	SHEET 1 OF 1
		SCALE 1:2

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